

January-05-12 10:41:00 AM

**\*78332\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 05/01/2012    **Start Qty:** 4.00 *1.0*    **\*4\***

**Cust Item ID:**

**Required Date:** 19/01/2012      **Req'd Qty:** 4.00      **\* 1 \***

**Customer:**

**Reference:**

Approvals: Process Plan: M.L.J Date: 12/01/05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3560	Rev D

100

0.00

**\*100\***

BAND SAW

## Bandsaw

## Memo

0.00

## Jeaspa Bandsaw

Cut blanks 15.500" long

110

0.00

**\*110\***

## HAAS CNC VERTICAL MACHINING #1

HAAS 1

## Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA696 Rev: **AA** & Dwg D3560 Rev: **D**

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78332****\*78332\***

Page 2

January-05-12 10:41:00 AM

Item ID: D3560-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Arm Weldment  
Start Date: 05/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 19/01/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
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**\*130\***

QC

Memo

Quality Control

140

**\*140\***

Large Fab

Large Fab

Large Fab

Memo

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad )

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch ( 65 deg C )

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

Alm. Rod M117912

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## January-05-12 10:41:00 AM

Page 3

## Hand Finishing

+2

-04

2 0 BE12-01-20

2 BK 12-1-34.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 78332****\*78332\***

Page 4

January-05-12 10:41:00 AM

Item ID: D3560-044 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Arm Weldment  
Start Date: 05/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 19/01/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC3- Inspect Part Finish	0.00							
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**\*180\***

QC

Memo

0.00

Quality Control

2X4 M 12/01/24

190		0.00							
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**\*190\***

Small Fab

Small Fab

Memo

0.00

Small Fab

I-Press bushing in D3560 arm per dwg D3562

12/01/24 (2)

200	QC5- Inspect part completeness to step on W/O	0.00							
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**\*200\***

QC

Memo

0.00

Quality Control

5 12/01/24

(x2)

044

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 78332

January-05-12 10:41:00 AM

**\*78332\***

Page 5

Item ID: D3560-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Arm Weldment  
Start Date: 05/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 19/01/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>W18</u>	0.00							
<b>*210*</b>									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL ***								
220	QC21- Final Inspection - Work Order Release	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									

*12-01-25* *2* *0*

*12/1/25* *[Signature]*

*12-01-25* *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-05-12 10:41:04 AM

Page 1

Work Order ID: 78332

**\*78332\***

Parent Item: D3560-044

**\*D3560-044\***

Parent Item Name: Arm Weldment

Start Date: 05/01/2012

Required Date: 19/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC  
IPP Rev B ECN 987 07.10.09 EC verified by DD  
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2808		Manufactured	No			100	Each	22.0000	1	4			
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**\*D2808\***

Bushing

Location	Loc Qty	Loc Code
GA	22	
32896	2	
71879	8	
76188	12	

M6061T6B0.500X05.00 0		Purchased	No			140	f	38.4750	1.295	5.452632			
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**\*M6061T6B0 500X05 000\***

6061-T6 Bar .500 x 5.00

Location	Loc Qty	Loc Code
MAT001	38.475	
112154	6.935	
117933	7.54	
119324	24	

D3592-1		Manufactured	No			190	Each	9.0000	1	4			
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**\*D3592-1\***

Plate

Location	Loc Qty	Loc Code
WA002	9	
47015	2	
48517	7	

W/O:		WORK ORDER CHANGES					
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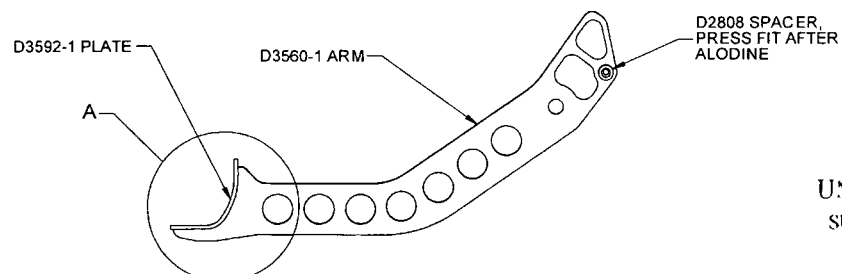
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

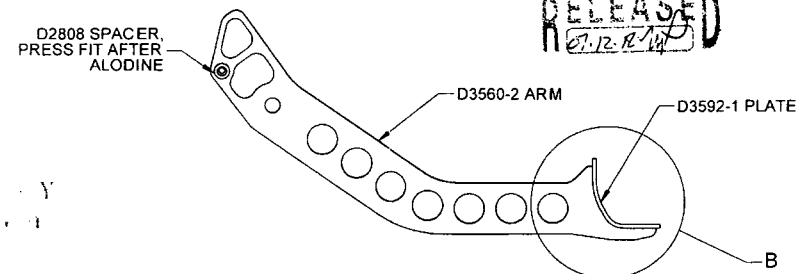
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

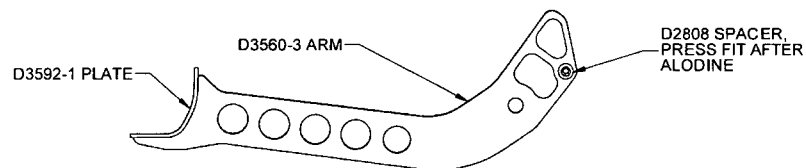
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27.12.14



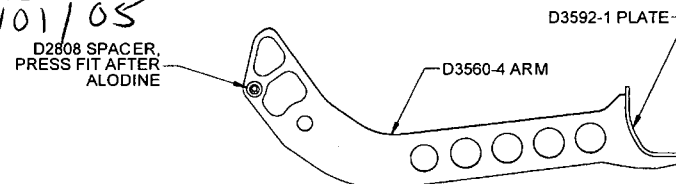
**D3560-041 ARM WELDMENT**



**D3560-042 ARM WELDMENT**

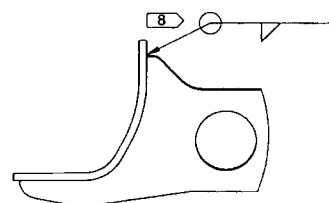


**D3560-043 ARM WELDMENT**



**D3560-044 ARM WELDMENT**

UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WORK IN PROGRESS  
NO. 78332 M/LJ  
12/01/05



**DETAIL A  
SCALE 1:2**

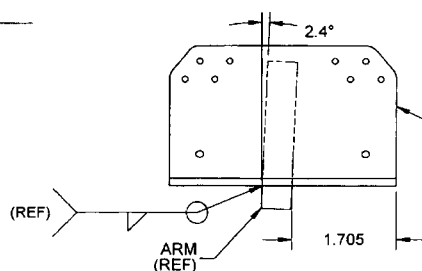
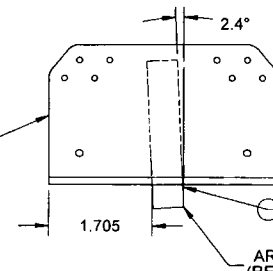
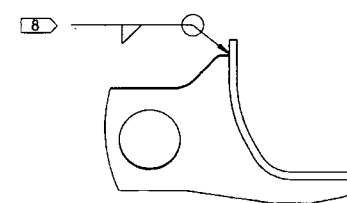


PLATE  
(REF)



ARM  
(REF)



**DETAIL B  
SCALE 1:2**

**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D  
SHEET 1 OF 5  
TITLE **ARM WELDMENT** SCALE 1:4

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- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.23 lbs (TYP)  
8) WELDING: PER DART QSI 004

W/O:		WORK ORDER CHANGES					
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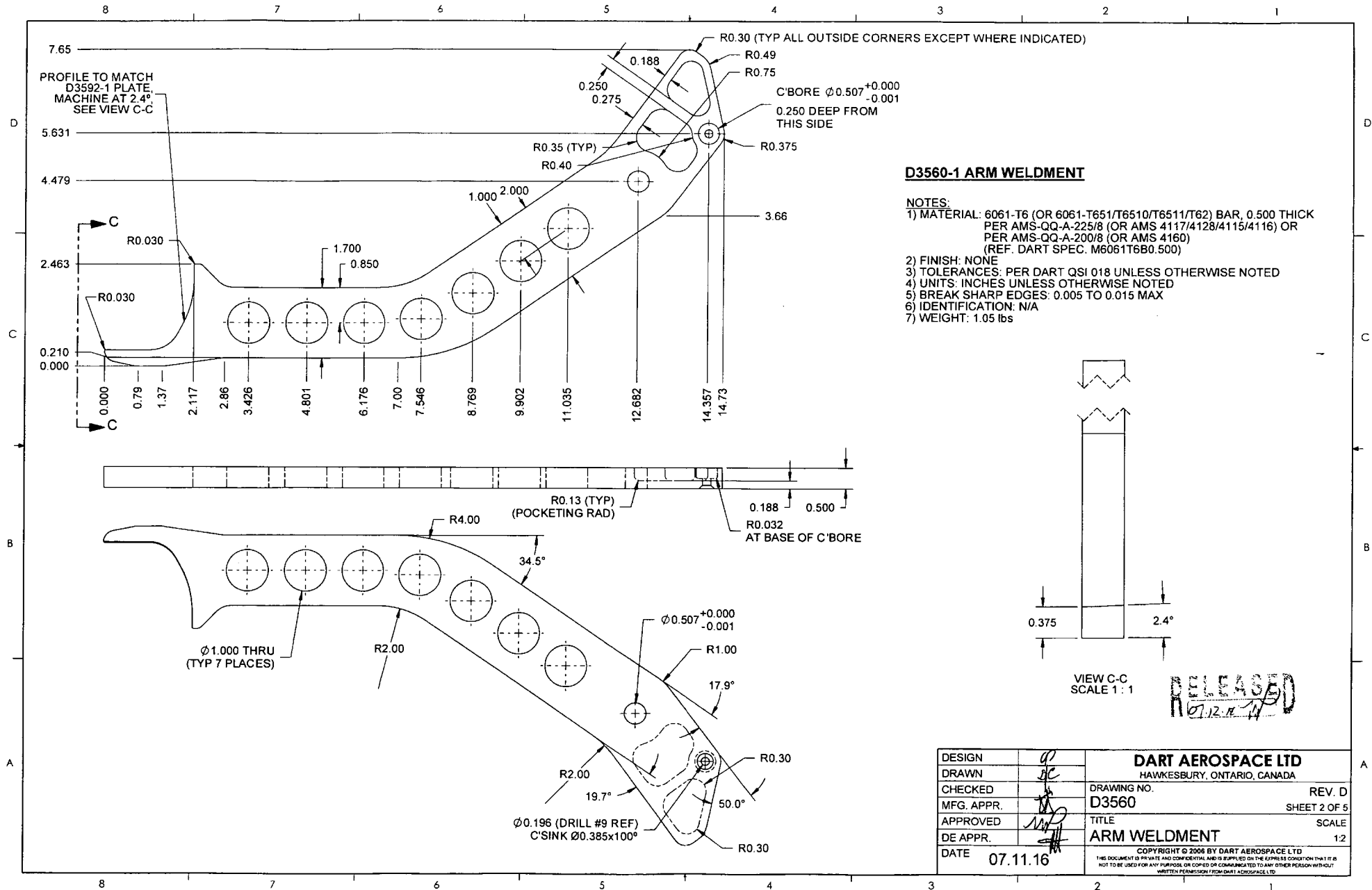
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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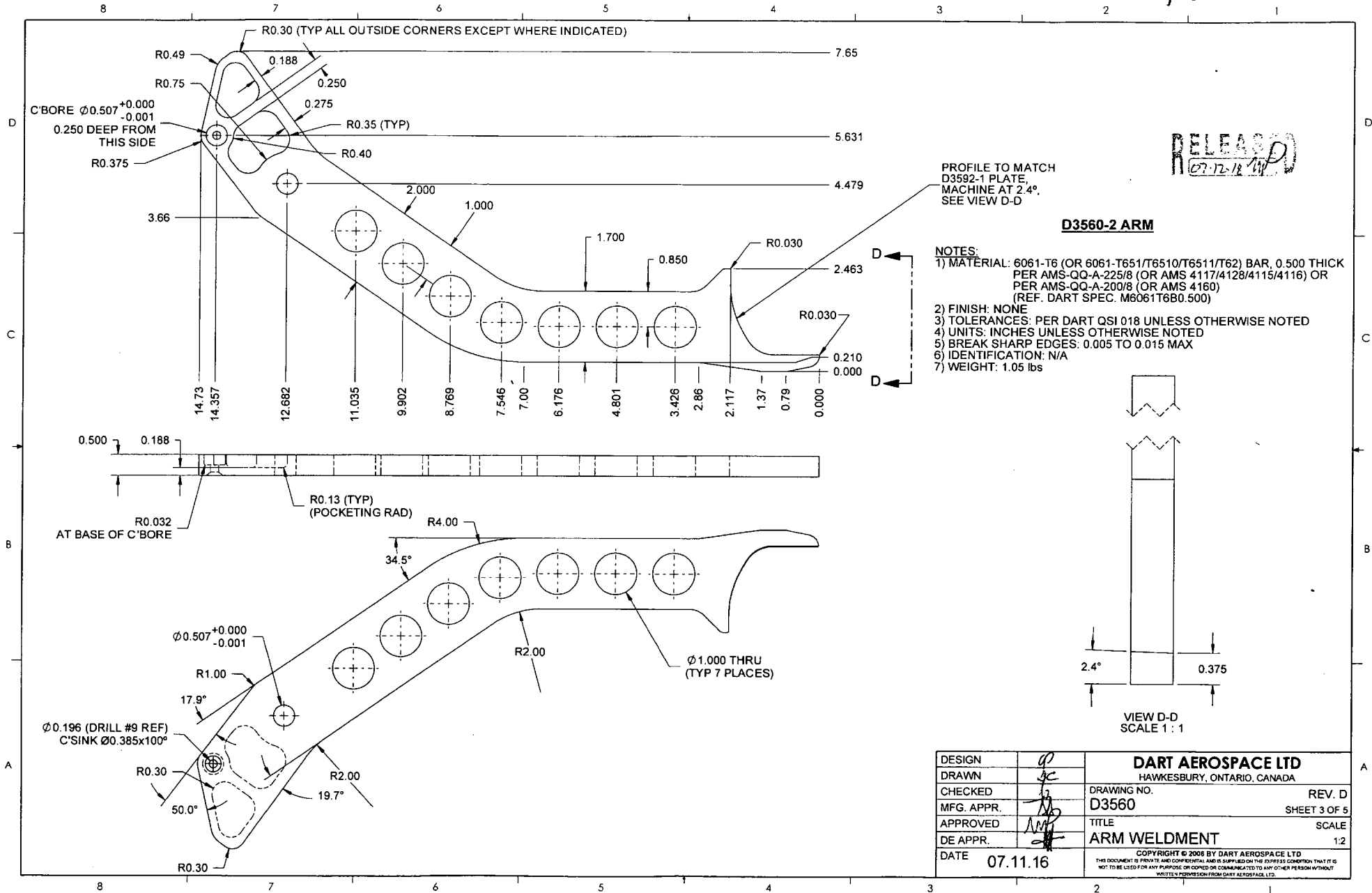
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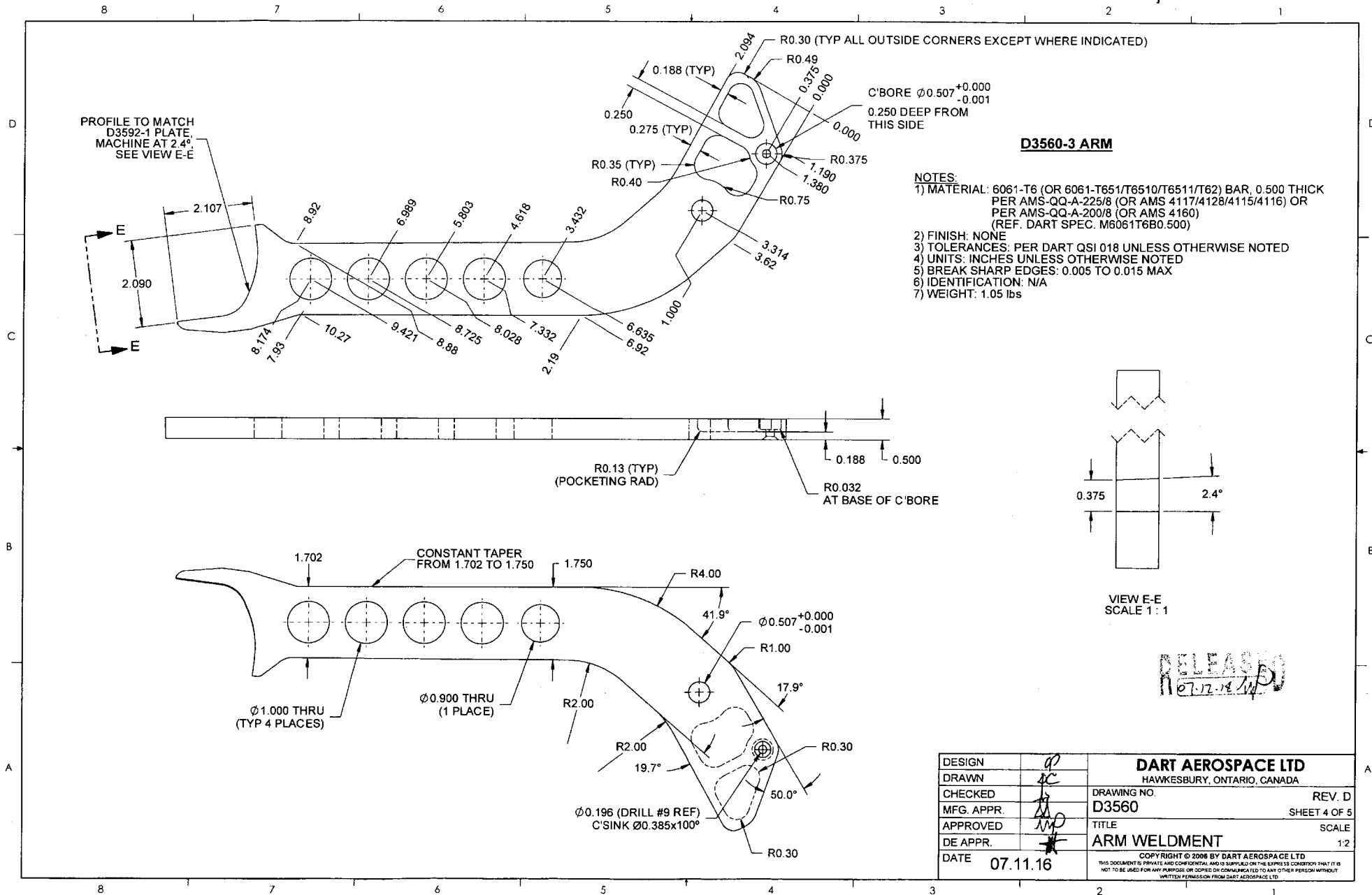
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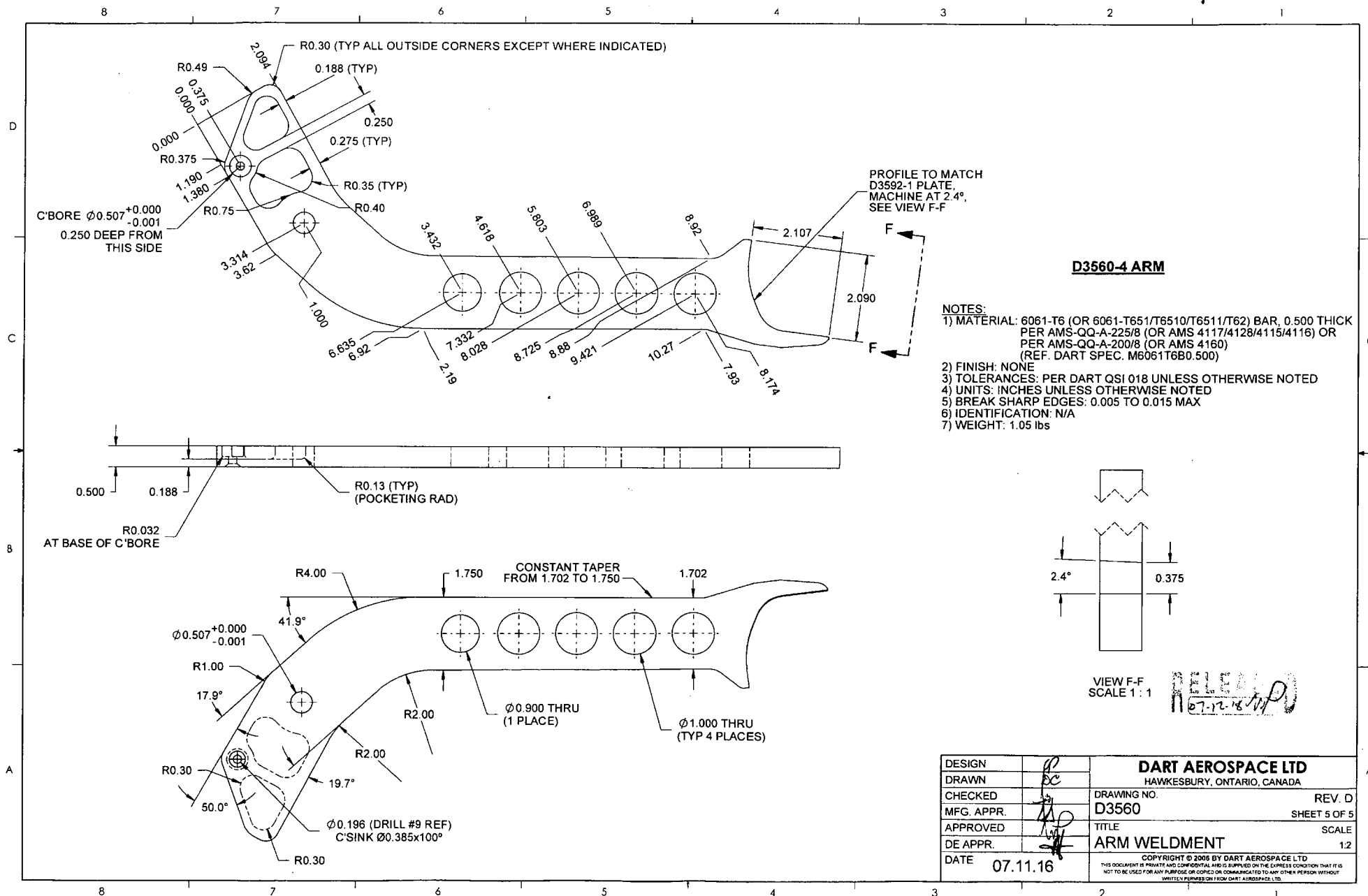
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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70332



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